

Date: Monday, 11/21/2005 10:06:44 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STEP WELDMENT |
| Job Number | : 24917 | | |
| Estimate Number | : 10779 | | |
| P.O. Number | : N/A | Part Number | : D3463041 |
| This Issue | : 11/21/2005 S.O. No. : N/A | Drawing Number | : D3463 REV.A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : LARGE FAB ASSY | Drawing Revision | : A |
| Previous Run | : N/A | Material | : N/A |
| Written By | : SEE COMMENT below | Due Date | : 11/28/2005 |
| Checked & Approved By | : SEE COMMENT below | Qty: | 1 Um: Each |
| Comment | : EST REV. A 05.11.18 new issue EC | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|----------------------|
| 1.0 | 238806 | SS DOWEL PIN 1" LONG |
|-----|--------|----------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| | | | |
|-----|-------------|----------------------|--------|
| Qty | Part Number | Description | Batch |
| 2 | 238-806 | SS DOWEL PIN 1" LONG | M19080 |

| | | |
|-----|--------|--------|
| 2.0 | D34533 | Clevis |
|-----|--------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|---------|
| Qty | Part Number | Description | Batch |
| 1 | D3453-3 | Clevis | B 24735 |

| | | |
|-----|--------|----------|
| 3.0 | D34637 | Drag Arm |
|-----|--------|----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch |
| 1 | D3463-7 | Drag Arm | B24932 |

| | | |
|-----|--------|-----|
| 4.0 | D34631 | Arm |
|-----|--------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch |
| 1 | D3463-1 | Arm | B25341 |

AA 06/01/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/04/16
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: / Monday, 11/21/2005 10:06:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 24917

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3463-3 | Step | B24929 |

6.0

D34635F

Step Flat Pattern



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------------|--------|
| 2 | D3463-5F | Step Flat Pattern | B24931 |

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3453-5 | Plug | B24935 |

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463

~~06/01/06~~
~~06/01/06~~

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

B06.01.06

~~06/01/06~~

PD 06-01-06

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

~~N/A used for testing~~
06 01 09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 24917

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



11 06.01.10

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

~~N/A used for sending~~

5

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

~~N/A~~

11 06.01.10

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~N/A~~

~~06.01.10~~

11 06.01.11

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

500 06/01/12 (1)

100 06/01/16

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

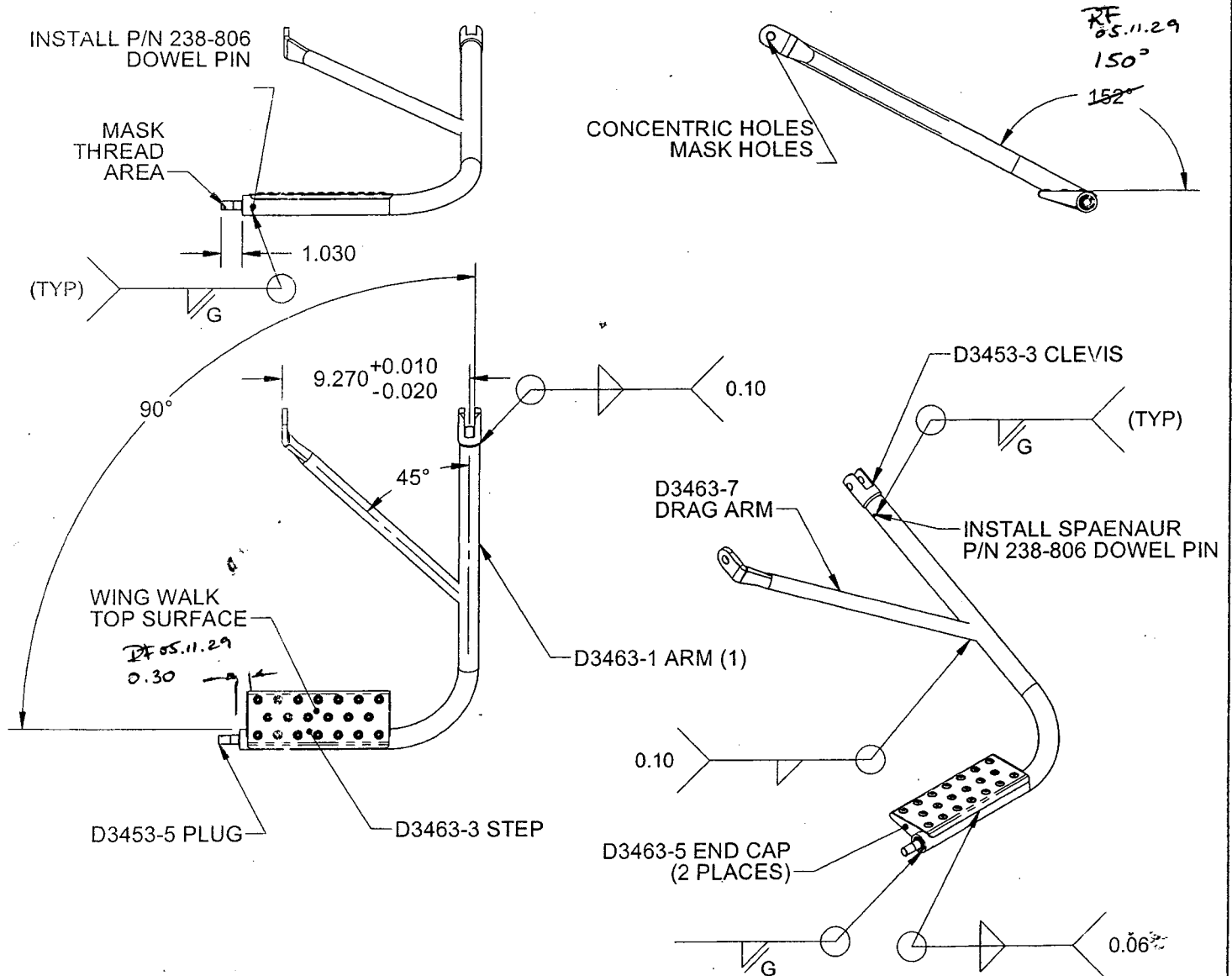
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

PRELIMINARY ISSUE

| | | | |
|------------------|------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3463 | REV. A SHEET 1 OF 4 |
| DATE 05.09.20 | TITLE STEP WELDMENT | | SCALE 1:8 |
| A | 05.09.20 | NEW ISSUE | |



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKER SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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